

DP- 309551

**A HEATING, VENTILATION, AND AIR CONDITIONING SYSTEM HAVING A
FILM VALVE AND FILM FOR CONTROLLING AIR FLOW**

RELATED APPLICATION

5 **[0001]** This patent application claims priority to and all advantages of United States
Provisional Patent Application 60/448,321, filed February 18, 2003.

TECHNICAL FIELD

[0002] The subject invention generally relates to a heating, ventilation, and air
conditioning system including a housing and a film valve in the housing for controlling air
10 flow. More specifically, the film valve includes a film that controls the air flow.

BACKGROUND OF THE INVENTION

[0003] Control surfaces are known in the art. To date, rigid doors have been used as
control surfaces to control air flow within a housing of a heating, ventilation, and air-
conditioning unit (HVAC). Recently, composite structures have been designed to replace
15 these conventional rigid doors. Specifically, the composite structures have been designed as
flexible films. The film controls airflow by opening and closing apertures in inlets and
outlets of the housing of the HVAC system. Generally, the film is disposed in a film valve
assembly that includes a frame having rollers. To control air flow, an actuator moves a first
roller to wind and unwind the film. As the film is wound and unwound, the openings in the
20 film align with the apertures in the housing, thus allowing air to flow through the housing.

[0004] Prior art control surfaces, such as rigid doors, are well known to those skilled
in the art and include substrates including filled polypropylene or nylon plastic covered by a
semi-open or open cell foam, or an overmolded rubber. The disadvantages of using these
control surfaces include a need for additional packaging volume within the HVAC system
25 and the separation of hot and cold air streams resulting in decreased air mixing efficiency.

DP- 309551

[0005] Additionally, prior art control surfaces such as films are also well known to those skilled in the art and include both elastomeric and non-elastomeric layers disposed on substrates including fabrics and polymers. Yet, in every case, the prior art films do not sufficiently perform when tested in the housing of the HVAC system. Common
5 disadvantages of prior art films include accumulation of static charge, high coefficients of friction, film blocking, film creep, high bending resistance, lack of noise reduction, and tacky surfaces.

[0006] Specifically, accumulation of static charge causes airborne debris to attach to surfaces of the film resulting in noise production as the film is moved within the housing of
10 the HVAC system. High coefficients of friction require the film valve assembly to be equipped with larger actuators to overcome the possibility that the film will stick, slip, or get stuck in one position. Film blocking results in noise production as the film is separated from itself as the film is unwound from the rollers. Film creep results in stretching that leads to the misalignment of the film within the housing of the HVAC system. High bending resistance
15 requires the film valve assembly to be equipped with larger actuators to overcome the possibility that the film will not efficiently wind onto the rollers. A lack of noise reduction is caused by the excessive vibration of the film when disposed in the film valve assembly, resulting in unacceptable noise levels within the housing of the HVAC system. Finally, tacky surfaces result in the generation of peeling noises as the film breaks contact with the rollers.

[0007] Theoretically, many different composite structures could be used as films in
20 the housing of the HVAC system. One such composite structure is disclosed in U.S. Patent 5,217,797 to Knox, et al. This patent discloses a composite structure that includes a substrate including perfluoropolymer fibers sandwiched between a perfluoropolymer layer and an elastomeric layer. Further, the substrate can be reinforced by glass, quartz, aramid, or nylon

DP- 309551

fiber. Yet, this patent does not disclose a silicone topcoat layer disposed on an elastomeric layer.

[0008] Yet, the composite structure disclosed in U.S. Patent 5,217,797 is not the sole prior art. Other attempts have been made to produce films or composite structures that overcome all of the aforementioned disadvantages. Such attempts include a composite structure for use in the housing of the HVAC system described in European Patent 0 705 725 A1 to Higashihara of Denso, formerly Nippondenso Co. Ltd. of Aichi-ken, Japan. This patent discloses a composite structure including seven layers. More specifically, the patent discloses a composite structure including a polyphenylene sulfide layer and an adhesive epoxy layer disposed on both sides of the polyphenylene sulfide layer. The polyphenylene sulfide layer and the adhesive epoxy layer are sandwiched between two nylon layers. The two nylon layers are further sandwiched between two layers of silicone.

[0009] The composite structure described in European Patent 0 705 725 A1 is further described in a 1996 SAE article 960687 entitled "Development of a Film Door Type Air Conditioning Unit." This article discloses the inability of a silicone film alone to adequately reduce noise in the housing of the HVAC system.

[00010] Additionally, a composite structure of a very similar but slightly different design to the European Patent 0 705 725 A1 by Denso was also tested. The composite structure is used by Lexus, a division of The Toyota Motor Company of Toyota City, Japan, as a film in the housing of the HVAC system designed by Denso for the 1995 Lexus LS400. This composite structure includes a polyphenylene sulfide layer and a binder layer including alumina trihydrate disposed on both faces of the polyphenylene sulfide layer. The polyphenylene sulfide layer and the alumina trihydrate binder layers are sandwiched between two nylon layers. The two nylon layers are further sandwiched between two layers of silicone.

DP- 309551

[00011] Several of the Lexus HVAC systems and the corresponding composite structures were removed from used automobiles and analyzed. The analyses showed that the aforementioned composite structures yielded unsatisfactory results due to excessive nylon fraying. It is known to those skilled in the art that non-coated fibers will fray. In the tested
5 HVAC systems and the corresponding composite structures, the excessive nylon fraying resulted from an incomplete sandwiching of the two nylon layers with the two layers of silicone. Specifically, the incomplete sandwiching resulted from the two layers of silicone disposed only on a top edge of the two nylon layers, as opposed to being fully disposed entirely over the two nylon layers. The incomplete sandwiching caused the nylon layers to
10 wear. The frayed nylon became intertwined with the rollers of the film valve assemblies, thus reducing the ability of the composite structures to freely move and rendering the composite structures unusable.

[00012] Additionally, the analyses showed that the aforementioned composite structures yielded unsatisfactory results due to excessive nylon freezing. Specifically, if the
15 evaporator core produces condensation, the nylon-fibers will absorb the condensation. Once the nylon-fibers absorb the condensation, the nylon-fibers will freeze in low temperatures, and increase in stiffness. The increase in stiffness will render the nylon-fiber unusable.

[00013] Additionally, component level debris intrusion testing of the composite structures showed that airborne debris was embedded in surfaces of the composite structures.
20 The airborne debris resulted in the generation of noise as the composite structures were moved in the housing of the HVAC systems.

[00014] In another attempt to develop a composite structure that overcomes the aforementioned disadvantages of prior art control surfaces, Nippondenso Co. Ltd. of Aichi-ken, Japan developed a film disclosed in U.S. Pat. 5,326,315. This patent discloses a film
25 that includes at least two kinds of layers having different characteristics, for example, a film

DP- 309551

layer provided on at least one side of a cloth layer, or a resin material disposed on one side of the cloth layer. That is, two different kinds of layers are provided such as a film layer and a fabric layer, or a resin layer and a fabric layer.

[00015] Specifically, the film includes six embodiments. In a first embodiment, the film includes a resin film layer, a cloth layer disposed on the resin film layer, and a resin coat layer disposed on the cloth layer. In a second embodiment, the film includes the resin film layer and the cloth layer. The cloth layer is disposed on the resin film layer with an adhesive. In a third embodiment, the film includes the resin film layer and the cloth layer. The cloth layer is disposed on the resin film layer with the adhesive, and the resin coat layer is impregnated in the cloth layer. In a fourth embodiment the film includes the cloth layer and the resin film layer. The resin film layer is disposed on the cloth layer with the adhesive. In a fifth embodiment, the film includes the cloth layer and the resin coat layer. The resin coat layer is impregnated in the cloth layer. In the sixth embodiment, the film includes the cloth layers disposed on the resin film layer with the adhesive. Additionally, in the sixth embodiment, the resin film layer is disposed on the cloth layer with the adhesive.

[00016] The resin film layer includes PPS (polyphenylene sulfide), PET (polyethylene terephthalate), PEN (polyethylene naphthalate), PEI (polyether imido), PI (polyimido), PES (polyether sulfone), PEEK (polyether etherketone), PSF (polysulfone), PC (polycarbonate), PVC (polyvinyl chloride), and PS (polysulfone).

[00017] The cloth layer can include filaments of nylon fibers, PET fibers, PPS fibers, aramid fibers, p-aramid fibers, novoloid fibers, polytetrafluoroethylene fibers, glass fibers, carbon fibers, and boron fibers. Also, the resin coat layer includes silicon resin, acrylic resin, or fluorocarbon resin.

[00018] The film disclosed in this patent does not include a silicone topcoat layer disposed over an elastomeric layer. Therefore, if this film is used as the film in the housing

DP- 309551

of an HVAC system, the absence of the elastomeric layer allows for excess vibration leading to excessive noise generation, and thus not improving on the aforementioned disadvantages.

[00019] In another attempt to develop a composite structure that overcomes the aforementioned disadvantages of prior art control surfaces, Milliken & Company of Spartanburg, South Carolina developed a film disclosed in International Patent WO 01/70529 A1. This patent discloses a film including a synthetic, continuous, multi filament, non-textured yarn layer with improved dimensional stability & creep resistance. Further, the patent discloses the yarn's floats reducing the coefficient of friction of the film and the noise generated when the film moves in the housing of the HVAC system. Still further, the application discloses the use of a polyurethane and /or polyacrylate layer disposed on the yarn layer that reduces fray resistance as the film moves in the housing of the HVAC system. Yet, this patent does not disclose a silicone topcoat layer disposed on an elastomeric layer.

[00020] When tested, the Milliken film yields unsatisfactory results. Specifically, airborne debris becomes imbedded in the film thus generating noise as the film moves in the housing of the HVAC system. Additionally, after the film was exposed to heat, the edges curled and frayed therefore rendering the film unusable.

[00021] In yet another attempt to overcome the aforementioned disadvantages of prior art control surfaces, composite structures designed for use in non-automotive industries were also researched and tested as films in the housing of the HVAC system. Examples of such composite structures include a helium barrier developed by Mann Industries, a division of Takata Global Group of Tokyo, Japan, and two coated woven surfaces disclosed in the U.S. Patent 5,230,937 to Effenberger and in U.S. Patent Application 2001/0034170 to Keese.

[00022] The helium barrier developed by Mann Industries includes a 70 denier polyester plain weave fabric sandwiched between two polyurethane primer layers. Further, a polyurethane film layer is disposed on a first face of one of the polyurethane primer layers.

DP- 309551

Specifically, the helium barrier does not include a silicone topcoat layer disposed on an elastomeric layer.

[00023] When tested, the 70 denier fabric did not have sufficient structural rigidity to keep the helium barrier from curling after exposure to high temperatures. In an attempt to overcome the curling of the composite structure, 75 and 150 denier polyester fabrics were substituted in the aforementioned helium barrier and evaluated. When exposed to high temperatures, the 75-denier fabric also exhibited a tendency to curl. Conversely, the 150-denier fabric, when exposed to high temperatures, did not curl.

[00024] Additionally, testing also showed that when the helium barrier was placed in the housing of the HVAC system airborne debris became imbedded in the polyurethane primer layer. As the helium barrier was moved within the housing of the HVAC system, the imbedded airborne debris generated unacceptable noise. Yet, the airborne debris did not imbed in the polyurethane film layer.

[00025] In an attempt to remedy the noise generation, the polyurethane film layer was disposed on a face of both polyurethane primer layers in the aforementioned helium barrier. Although this construction of the helium barrier minimized noise generation, the helium barrier was found to adhere to itself. Additionally, the helium barrier was found to exhibit a high coefficient of friction when moved within the housing of the HVAC system. Further, diatomaceous earth was added to the film in an attempt to reduce the film's tendency to adhere to itself. Yet, this had no positive effect.

[00026] As an alternative to the helium barrier developed by Mann Industries, the Effenberger patent discloses a composite structure including a substrate that is unlike the helium barrier. The substrate is preferably a textile substrate, coated on one or both faces with a matrix. The matrix includes an initial perfluoropolymer layer and a fluoroelastomer overcoat layer. In some embodiments, a methylphenyl silicone oil is also added to the

DP- 309551

matrix. More specifically, the Effenberger patent does not disclose a composite structure that includes a silicone topcoat disposed on an elastomeric layer.

[00027] In a first embodiment of the Effenberger patent, a perfluorinated polymer is disposed, as an initial layer, on one or both faces of the substrate. Additionally, a
5 fluoroelastomer layer is disposed, as an overcoat layer, on the initial perfluoropolymer layer.

[00028] In a second embodiment of the Effenberger patent, the methylphenyl silicone oil is applied simultaneously with the perfluoropolymer thus forming a mixed perfluoropolymer layer disposed on the substrate. In a third embodiment of the Effenberger patent, the methylphenyl silicone oil is applied to the substrate first, followed by an
10 application of the perfluoropolymer, thus resulting in a methylphenyl silicone oil layer sandwiched between the perfluoropolymer layer and the substrate. Additionally, in all of the aforementioned embodiments, multiple fluoroelastomer layers may be added as topcoat layers, if so desired.

[00029] Specifically, the substrate of the Effenberger patent may include glass,
15 fiberglass, ceramics, graphite, polybenzimidazole, polyaramides, polytetrafluoroethylene, metal, polyolefins, polyesters, polyamides, copolymers of tetrafluoroethylene, polyether sulfones, polyimides, polyether ketones, polyetherimides, novoloid phenolic fibers or natural textiles. The initial perfluoropolymer layer and the overcoat fluoroelastomer layer include polytetrafluoroethylene, ethylene-propylene copolymers, or copolymers of
20 tetrafluoroethylene and perfluoro-propyl vinyl ether.

[00030] The Keese application discloses a substrate that is also unlike the helium barrier developed by Mann Industries. The Keese application discloses a substrate and a perfluoropolymer layer disposed on a first and second face of the substrate. Additionally, a colloidal silica dispersion and a perfluorinated copolymer resin dispersion are disposed on the

DP- 309551

second face of the substrate to render the surface bondable. Finally, an elastomeric layer is disposed on the colloidal silica dispersion and the perfluorinated copolymer resin dispersion.

[00031] More specifically, the substrate is reinforced with glass or fiberglass.

Additionally, the perfluoropolymer layer includes polytetrafluoroethylene or other similar

5 compounds. Further, the elastomeric layer includes a silicone rubber. Still further, the

perfluorinated copolymer resin dispersion includes fluorinated ethylene propylene or

perfluoroalkoxy-modified tetrafluoroethylene. Specifically, the colloidal silica dispersion

disposed on the second face of the substrate is not elastomeric. The colloidal silica dispersion

is defined as spheres of silica dispersed in an alkaline medium that produce a negative charge.

10 Finally, the Keese application does not disclose a silicone topcoat layer disposed on the top of the elastomeric layer.

[00032] When tested, both the Effenberger and Keese composite structures also

yielded unsatisfactory results. Specifically, the perfluoropolymer layer and the elastomeric

layer of the composite structures accumulated static charge thus allowing airborne debris to

15 become lodged on the surfaces of the perfluoropolymer layer and the elastomeric layer. This

resulted in unacceptable noise as the composite structures were moved between open and

closed positions within the housing of the HVAC system.

[00033] Further, the elastomeric layer of the composite structure of Keese yielded a

tacky surface with a high coefficient of friction. The high coefficient of friction prevented

20 the composite structure from being moved between open and closed positions within the

housing of the HVAC system when the elastomeric layer was in contact with the housing of

the HVAC system. Additionally, the tacky surface contributed to airborne debris becoming

lodged on the tacky surface resulting in unacceptable noise as the composite structures were

moved between open and closed positions within the housing of the HVAC system. Still

DP- 309551

further, as the surface made and broke contact with the rollers, unacceptable noise was generated.

[00034] Although the prior art composite structures are currently used in various applications, there remains an opportunity for the development of a composite surface that exhibits superior longevity and physical properties to be used as a film in HVAC systems of motor vehicles.

SUMMARY OF THE INVENTION

[00035] The subject invention provides a heating, ventilation, and air conditioning (HVAC) system including a housing defining an air inlet and an air outlet for directing air flow between the inlet and outlet. The HVAC system further includes a film. The film includes a substrate disposed in the housing and is moveable between open and closed positions for controlling the air flow through the housing. The substrate includes a fiber selected from the group of polyester-based fibers, glass-based fibers, and combinations thereof. An elastomeric layer is disposed on the substrate. A silicone topcoat layer is disposed on the elastomeric layer to minimize the noise created as the substrate of the film moves between the open and closed positions.

[00036] The silicone topcoat layer of the film provides a film that has a low coefficient of friction. The elastomeric layer acts as a noise dampening agent in the HVAC system. Furthermore, the overall film is dimensionally stable and does not creep, has a low bending resistance, and is static dissipative.

BRIEF DESCRIPTION OF THE DRAWINGS

[00037] Other advantages of the present invention will be readily appreciated, as the same becomes better understood by reference to the following detailed description when considered in connection with the accompanying drawings wherein:

[00038] Figure 1 is a perspective view of an HVAC system;

DP- 309551

[00039] Figure 2 is a cross-sectional view of an HVAC system including a cross-sectional view of the film valve assembly;

[00040] Figure 3 is a perspective view of a film in a film valve assembly in a first position;

5 [00041] Figure 4 is a perspective view of the film valve assembly of Figure 3 in a second position;

[00042] Figure 5 is a fragmented perspective view of the film valve assembly having an actuator disposed in a spaced relationship;

[00043] Figure 6 is a fragmented perspective view of a roller;

10 [00044] Figure 7 is a fragmented perspective view of the roller and a cap;

[00045] Figure 8 is a fragmented perspective view of the film and the roller installed in the film valve assembly;

[00046] Figure 9a is a cross-sectional view of the film in accordance with the subject invention; and

15 [00047] Figure 9b is a cross-sectional view of the film including an optional binder layer.

DESCRIPTION OF THE PREFERRED EMBODIMENT

[00048] Referring to the Figures, wherein like numerals indicate like parts throughout
20 several views, a heating, ventilation, and air conditioning system (HVAC) is shown generally at **10**. The HVAC system **10** generally defines a housing **11** that defines an air inlet **15** and an air outlet **66**. The housing **11** includes a film valve assembly **17** that defines at least one aperture **12**, as shown in Figure 2. Also shown in Figure 2, the housing **11** defines a mixing chamber **18** therein. Further, the HVAC system **10** includes an evaporator assembly **13**
25 coupled to the housing **11**. The HVAC system **10** also includes a heater assembly **14** coupled to the evaporator assembly **13** and the housing **11**. The HVAC system **10** further includes control surfaces **58a**, **58b** disposed in the housing **11** that are moveable for controlling air flow. Additionally, the HVAC system **10** includes a fan assembly **16** disposed on the air inlet **15**.

DP- 309551

[00049] The evaporator assembly **13** and heater assembly **14** respectively include an evaporator core **19** and a heater core **20** enclosed within the housing **11**. Additionally, the air inlet **15** defines a passageway **21** having a cavity **22** at an end **23** thereof. The air inlet **15** further includes the fan assembly **16** having a fan **24** disposed in a fan housing **25**.

5 **[00050]** The evaporator core **19** is operatively controlled with the HVAC system **10**, and the heater core **20** regulates air temperature. The evaporator core **19** extends across an entire width of the housing **11** such that all air passes therethrough. The heater core **20**, conversely, extends along an edge **43** of the housing **11**.

[00051] Referring to Figure 2, the control surface **58a** is shown as a door. The control
10 surface **58a** may direct the air to flow around the heater core **20**. Air directed by the control surface **58a** around the heater core **20** flows up a back face of the heater core **20** and into the air mixing chamber **18**. Within the air mixing chamber **18**, un-heated air that passed solely through the evaporator core **19** is mixed with the air directed around the heater core **20** to achieve a desired temperature. The air then flows out of the mixing chamber **18** to the air
15 outlet **66**, as selected by an operator.

[00052] The control surface **58b** can be further defined as a film **63** housed within the film valve assembly **17**. The film **63** is suspended across at least one aperture **12** thus covering the air-mixing chamber **18**. The film **63** can be moved across at least one aperture **12** with rollers, pulleys, cords, or gears, and the like.

20 **[00053]** Referring to Figures 1 through 5, the film **63** defines openings **31**. The openings **31** align with the air outlet **66** such that air can flow out through the air outlet **66**. More specifically, the openings **31** in the film **63** actually align with the at least one aperture **12** that is defined by the film valve assembly **17**, which, as introduced above, is a component of the air outlet **66**. For example, when the openings **31** defined by the film **63** are at least

DP- 309551

partially aligned with at least one aperture 12, air can pass from the mixing chamber 18 through the film 63 and through the at least one aperture 12.

[00054] Referring to Figures 3 through 5 and 8, the film valve assembly 17 is shown in greater detail. The film valve assembly 17 generally includes a frame 26. The frame 26 includes first 53, second 54, and third 56 segments. Referring specifically to Figure 8, the frame 26 also includes a slot 49 which receives a cap 48 disposed on the frame 26. The cap 48 includes an alignment rib 32 that snaps into the slot 49. The frame 26 may include additional slots 49 and the cap 48 may include additional alignment ribs 32 matching the number of slots 49. Moreover, the cap 48 may include a fastener 50 for further securing the cap 48 to the frame 26.

[00055] Referring to Figures 3-6 and 8, the frame 26 also includes first and second rollers 27, 28. The film 63 has a first end 29 disposed on the first roller 27 and a second end 30 disposed on the second roller 28 with the film 63 extending therebetween. With specific reference to Figure 8, the first and second rollers 27, 28 are disposed on opposite ends 46, 47 of the frame 26 with the first and second ends 29, 30 of the film 63 coupled thereto. In addition, the film 63 may be supported and kept under tension by one or more idle rollers 33 rotatably supported on the frame 26.

[00056] The first roller 27 also includes a first biasing device 40. The first biasing device 40 continually urges the first roller 27 to rotate in a first direction under a first constantly applied force. Additionally, the second roller 28 includes a second biasing device 41. The second biasing device 41 continually urges the second roller 28 to rotate in a second direction under a second constantly applied force. The first 40 and second 41 biasing devices may be torsion springs, helical torsion springs or any other suitable members that provide torsional force.

DP- 309551

[00057] Referring specifically to Figure 5, an actuator 57 is coupled to the second roller 28 thereby providing a non-constant rotational torque. The actuator 57 may be a stepper motor, a direct current motor and gears, or any suitable actuator. The actuator 57 includes a rotatable connector 51 that interfaces the actuator 57 with the second roller 28 in female/male engagement. The actuator 57 transfers a positive rotational torque to the second roller 28. Alternatively, a second actuator 57 may be coupled to the first roller 27.

[00058] Referring to Figures 6 and 7, the first roller 27 is made from metal, plastic, or any other suitable material. The first roller 27 includes a cylinder 37 that is also made from metal, plastic, or any other suitable material. The cylinder 37 includes a hollow end 38 that accepts the first biasing device 40. The cylinder 37 also includes a beveled end 39 that accepts an axle 34. The axle 34 includes a flattened distal end 35. The flattened distal end 35 interfaces with the frame 26 to ensure that the axle 34 does not rotate. The cylinder 37 also includes a second end 36 extending from the hollow end 38. Finally, the cylinder 37 includes a locking rib 44.

[00059] The first roller 27 further includes a shaft 42 that is made from metal, plastic, or any other suitable material. The shaft 42 defines a groove 45 and is disposed annularly about the first biasing device 40 and the cylinder 37. This allows the locking rib 44 to slide into a groove 45.

[00060] With particular reference to Figures 1 and 2, the film 63 of the HVAC system according to a preferred embodiment of the present invention will now be described in greater detail. The film 63 includes a substrate 61. The film 63 is moveable over the frame 26 between open and closed positions for controlling the air flow through the housing 11.

[00061] With reference to Figures 9a, and 9b, the substrate 61 includes a fiber 52 selected from the group of polyester-based fibers, glass-based fibers, and combinations thereof. In a first preferred embodiment, in Figure 9a, a fluoropolymer layer 62 is disposed

DP- 309551

on a first face **64** of the substrate **61** and may include, but is not limited to, a perfluoropolymer such as polytetrafluoroethylene. The fluoropolymer layer **62** also includes an additive to make the fluoropolymer layer **62** non-electrically charging. An elastomeric layer **59** is disposed on a second face **65** of the substrate **61**. Finally, a silicone topcoat layer **60** is disposed on the elastomeric layer **59**. Preferably, the silicone topcoat layer **60** has a thickness of from 0.2 to 0.7 mils, and more preferably has a thickness of from 0.3-0.5 mils. The silicone topcoat layer **60** minimizes the noise created as the substrate of the film moves between the open and closed positions in the housing **11** of the HVAC system **10**.

[00062] In a second preferred embodiment, in Figure 9b, the fluoropolymer layer **62** is disposed on the first and second faces **64, 65** of the substrate **61** and may include, but is not limited to, a perfluoropolymer such as polytetrafluoroethylene. The fluoropolymer layer **62** also includes an additive to make the fluoropolymer layer **62** non-electrically charging. A mixture of a colloidal silica dispersion and a perfluorinated copolymer resin dispersion **68** is disposed on a face **67** of the fluoropolymer layer **62**. An elastomeric layer **59** is disposed on the mixture of the colloidal silica dispersion and the perfluorinated copolymer resin dispersion **68**. Finally, a silicone topcoat layer **60** is disposed on the elastomeric layer **59**. The silicone topcoat layer **60** minimizes the noise created as the substrate of the film moves between the open and closed positions in the housing **11** of the HVAC system **10**.

[00063] More specifically, in the preferred embodiment, the substrate **61** includes, but is not limited to, an industry standard 1080 style fiberglass. In an alternative embodiment, the substrate **61** includes, but is not limited to, a polyester woven fabric created from yarns between 40 and 200 denier. Specifically, nylon-based fibers are not included in the substrate due to the nylon-fibers' ability to absorb water and freeze.

[00064] Additionally, in the preferred embodiment, the additive includes carbon black, graphite, metallic powder, metallic flakes, and metallic fibers. Further, the elastomeric layer

DP- 309551

59 includes a silicone rubber. More specifically, the silicone rubber is a platinum catalyzed, solventless, addition-cure, 100 percent solids, liquid silicone rubber composition.

[00065] The liquid silicone rubber is composed of commercially available A and B components that are mixed in a specified ratio, typically 1:1 or 10:1. Each component includes vinyl-terminated polydimethylsiloxane polymers and may include fumed silica as a reinforcing filler, and/or extending fillers. Typically, the A component includes a catalyst and the B component includes a cross-linking agent and an inhibitor. The inhibitor is removed upon application of heat to the liquid silicone rubber, thus effecting a cure.

[00066] As the A component, the elastomeric layer **59** may incorporate an organic peroxide catalyst. The organic peroxide catalyst may be applied from a solvent solution, dried if necessary to remove the solvent solution and heated appropriately to effect a cure. Conversely, the elastomeric layer **59** may incorporate an atmospheric-moisture-activated acetoxycure system. The acetoxycure system may be dried if necessary to remove the solvent solution and allowed to remain exposed to moist air sufficiently long to effect a cure.

[00067] Further, in another alternative embodiment, the elastomeric layer **59** may include a urethane, instead of the silicone rubber.

[00068] Additionally, an example of the colloidal silica dispersion includes, but is not limited to, Ludox RTM 40, manufactured by DuPont of Wilmington, Delaware. Additionally, examples of the perfluorinated copolymer resin dispersion include, but are not limited to, fluorinated ethylene propylene or perfluoroalkoxy-modified tetrafluoroethylene.

[00069] Finally, in the preferred embodiment, the silicone topcoat layer **60** is formed from a silicone containing composition including a vinyl and methoxy function dimethyl siloxane. An example of a silicone containing composition including a vinyl and methoxy function dimethyl siloxane includes, but is not limited to, 3715 manufactured by Dow Corning Inc. of Midland, Michigan.

DP- 309551

[00070] To synthesize the film **63**, according to Figure 9b, a multi-step method is used.

In a first step, the substrate **61** is paid off a roll and coated on the first **64** and second side **65** with a fluoropolymer. The first **64** and second **65** sides are dipped in a 100 percent solid system of the fluoropolymer to form the fluoropolymer layer **62**. The fluoropolymer layer **62** is then wiped and heated sufficiently to sinter or fuse the fluoropolymer. Typically, the first step is repeated several times in order to apply a desired amount of fluoropolymer to the substrate **61** that is free of cracks and other defects. Alternately, the fluoropolymer layer **62** can be smoothed and consolidated by passing the substrate **61** through a calendar machine (not shown).

[00071] Ideally, the fluoropolymer layer **62** should be as thin as possible, while sufficient to achieve the desired function. Although a variety of thicknesses of the fluoropolymer layer **62** can be utilized, a thickness from 1-5 mils is preferred.

[00072] In a second step, the side **67** of the fluoropolymer layer is rendered bondable by coating with a mixture of a colloidal silica dispersion and a perfluorinated copolymer resin dispersion **68**.

[00073] Alternately, the side **67** of the fluoropolymer layer may be rendered bondable by treatment with a mixture of sodium metal, naphthalene, and a glycol ether, or alternately, a mixture of sodium metal and anhydrous ammonia. If applicable, other means for rendering the side **67** of the fluoropolymer layer bondable include, but are not limited to, corona treatment in special atmospheres, chemical and electrochemical treatments, metal sputtering, and vacuum deposition of metals or metal oxides.

[00074] In a third step, a controlled amount of an elastomeric material is applied to the side **67** of the fluoropolymer layer. The elastomeric layer **59** should be as thin as possible, while sufficient to achieve the desired function. Although a variety of thicknesses of the elastomeric layer **59** can be utilized, a thickness from 2-50 mils is preferred.

DP- 309551

[00075] In a final step, the elastomeric layer **59** is dipped in a silicone topcoat solution to form the silicone topcoat layer **60**. After dipping, the silicone topcoat layer **60** is wiped to remove excess solution and heated sufficiently to cure. Upon curing, the silicone topcoat layer **60** and the subject invention, is complete.

5 [00076] In a further alternative embodiment of the subject invention, the control surfaces **58a**, **58b** can also be defined as air dampers (not shown) within the HVAC system **10**. Air dampers may include one or more flow control vanes or blades which are moveable between a fully open position and a fully closed position by a drivetrain including a gearshaft.

[00077] Optionally, an actuator may be used to electrically control the air damper from
10 a distant location if desired and continuously adjust the closure position in response to an input. Further, the air damper may be oriented in any position as dictated by the particular application

[00078] The foregoing detailed description shows the preferred embodiments of the present invention are well suited to fulfill the objectives of the invention. It is recognized that
15 those skilled in the art may make various modifications or additions to the preferred embodiments chosen herein to illustrate the present invention, without departing from the spirit of the present invention. It should also be recognized that any feature of the invention can be used in combination with any other feature of the invention. Accordingly, it is to be understood that the subject matter sought to be afforded protection should be deemed to
20 extend to the subject matter defined in the appended claims, including all equivalents thereof.